

Date: Thursday, 8/3/2006 10:50:04 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : CLAMP
 Job Number : 28088
 Estimate Number : 12499
 P.O. Number : N/A
 This Issue : 8/3/2006 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : PURCHASED PARTS
 Previous Run : N/A
 Written By :
 Checked & Approved By : 06.08.03
 Comment : Est: A 06.08.01 New issue EC

Part Number : D2947041
 Drawing Number : D2947 REV 06.08.03
 Project Number : N/A
 Drawing Revision : BA
 Material : N/A
 Due Date : 8/10/2006 Qty: 4 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S16GA 304/316 .063 Sheet



Comment: Qty.: 0.0504 sf(s)/Unit Total : 0.2016 sf(s)
 304/316 .063 Sheet
 batch: M19059

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D2947.
 Dwg Rev: B2
 Prog Rev: B3
 2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5.0 D2182 Heat Shrink



Comment: Qty.: 0.8400 f(s)/Unit Total : 3.3600 f(s)
 Heat Shrink
 Cut 7.0" of D2182 batch: B17067

06.08.02 06.08.02 06.08.10 06/08/10

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06/03/10	1	2 bent was wrong	EC	Scrap & destroy	SB 06/03/10			
						80.0		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/03/27

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 8/3/2006 10:50:04 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAMP

Job Number: 28088

Part Number: D2947041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1-

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Deburr any rough edges

2- Install D2182 heat shrink to clamp per dwg D2947

2- Bend as per Dwg D2947

SB 06/08/10

(2)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

EC 06.08.10

(2)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Handwritten signature

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Handwritten notes: 11 to END. 06.08.24 N/A. dig to 0008 u

Job Completion



Handwritten notes: u 06.08.23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

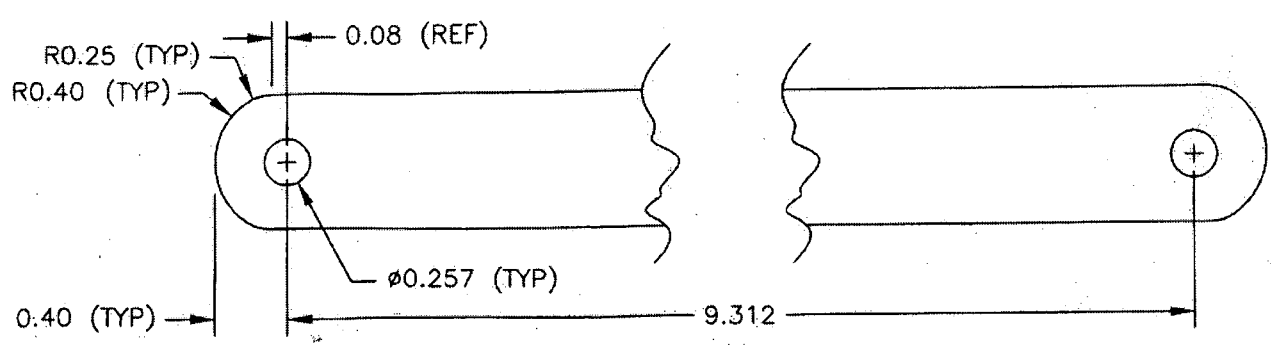
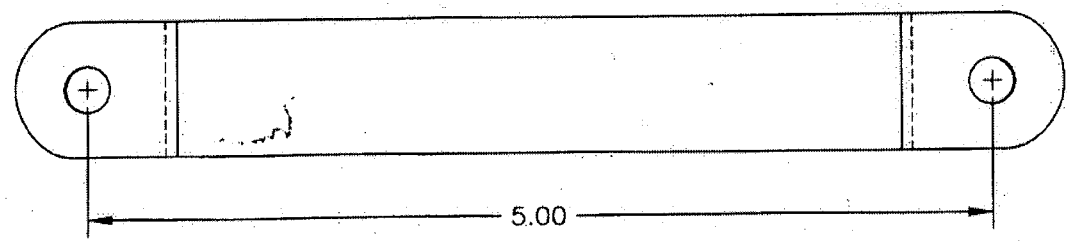
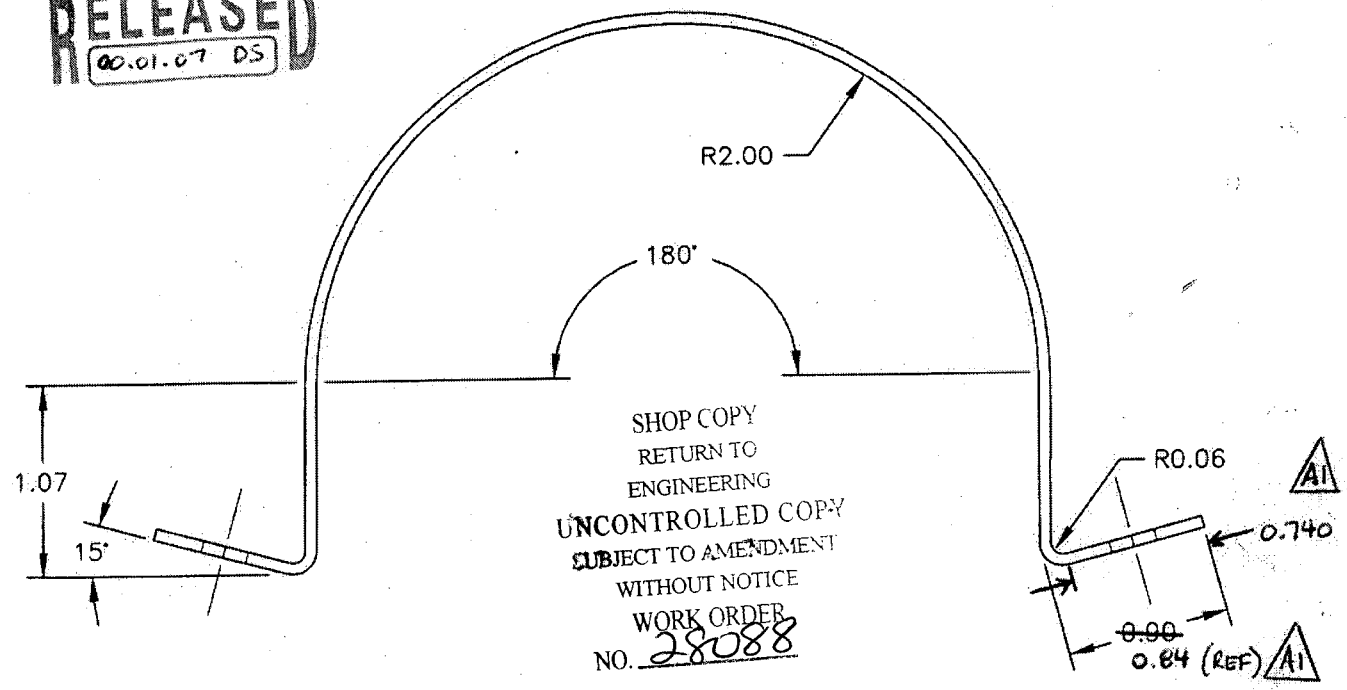
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2947	REV. A SHEET 1 OF 1
DATE 00.01.06		TITLE CLAMP	SCALE 1:1
A	00.01.06	NEW ISSUE	

RELEASED
00.01.07 DS



D2947 FLAT PATTERN

MATERIAL: AISI 304/316 SS 0.063 THICK x 0.75 WIDE
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

01.09.07 Add 0.740 dimension; 0.84 was 0.90

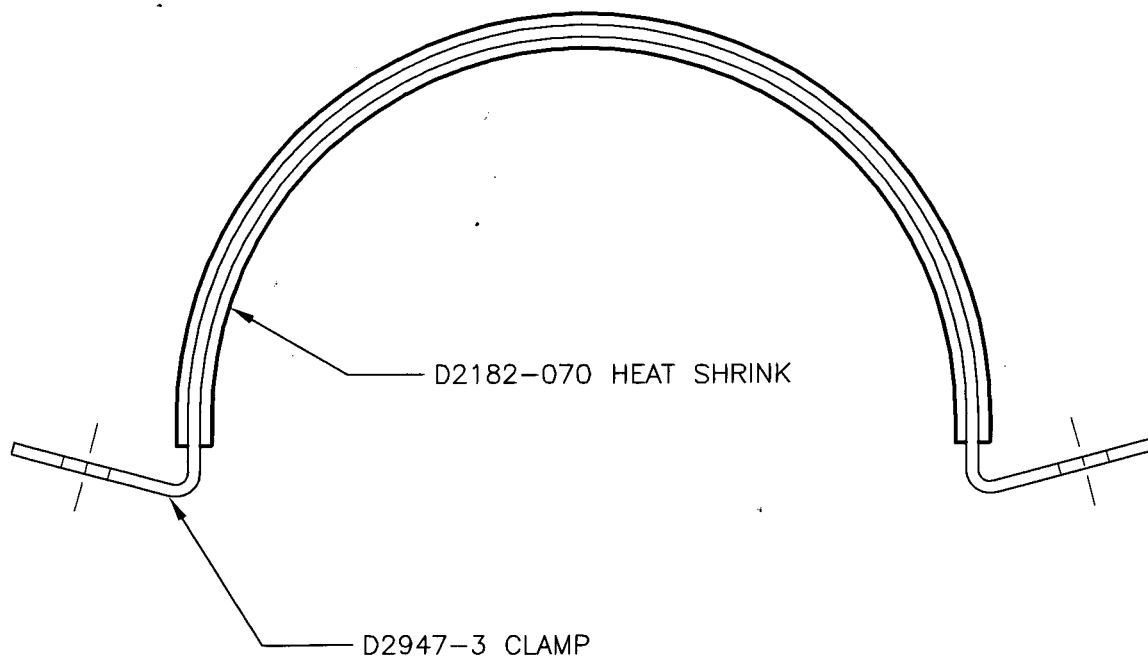
PRELIMINARY ISSUE

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CHECKED	APPROVED	DRAWING NO. D2947	REV. B SHEET 1 OF 3
DATE 06.06.30	TITLE CLAMP		SCALE 1:1
A	00.01.06	NEW ISSUE	
B	06.06.30	ADD D2947-041 AND D2947-3	

UNDER REVIEW

06.06.30 CB

prototype



D2947-041

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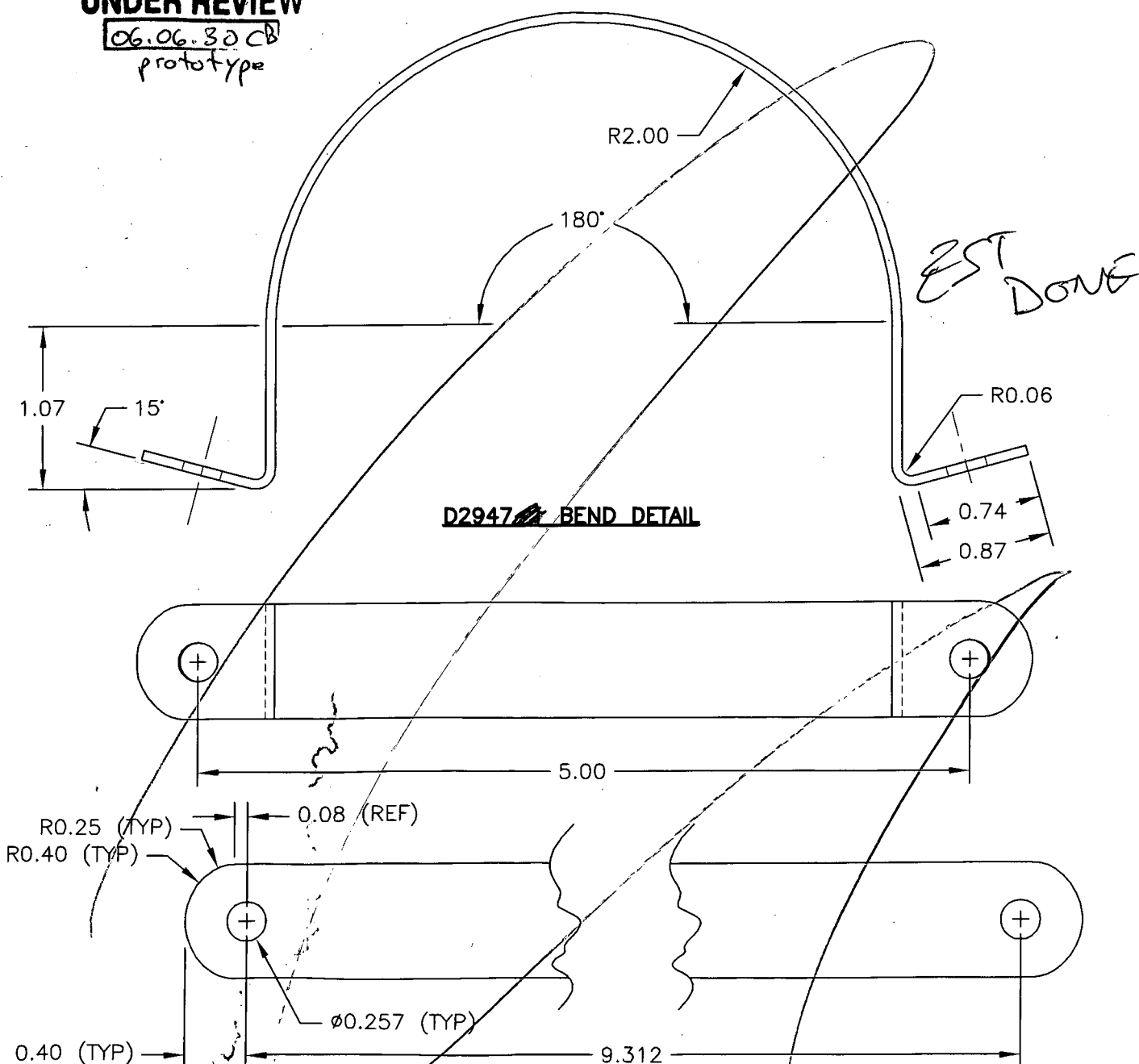
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DATE 06.06.30		TITLE CLAMP	SCALE 1:1

UNDER REVIEW

06.06.30 CB
prototype



D2947 BEND DETAIL

D2947 FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.063 THICK x 0.75 WIDE (REF DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP CORNERS 0.005 TO 0.010

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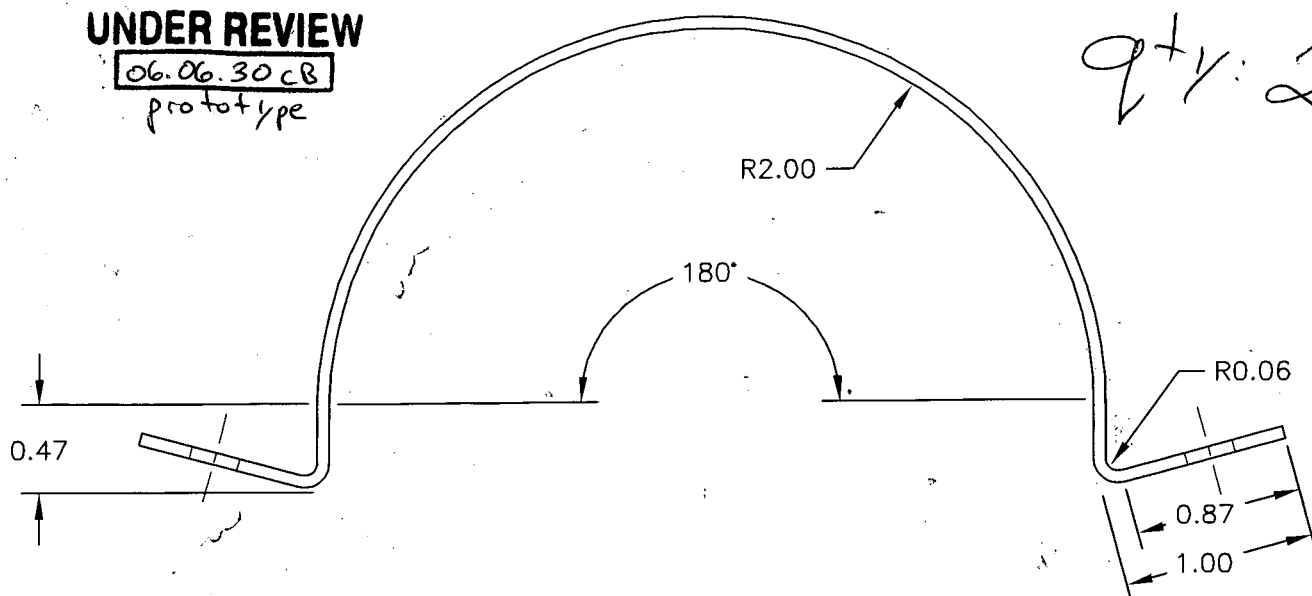
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DATE 06.06.30		TITLE CLAMP	SCALE 1:1

UNDER REVIEW

06.06.30 CB

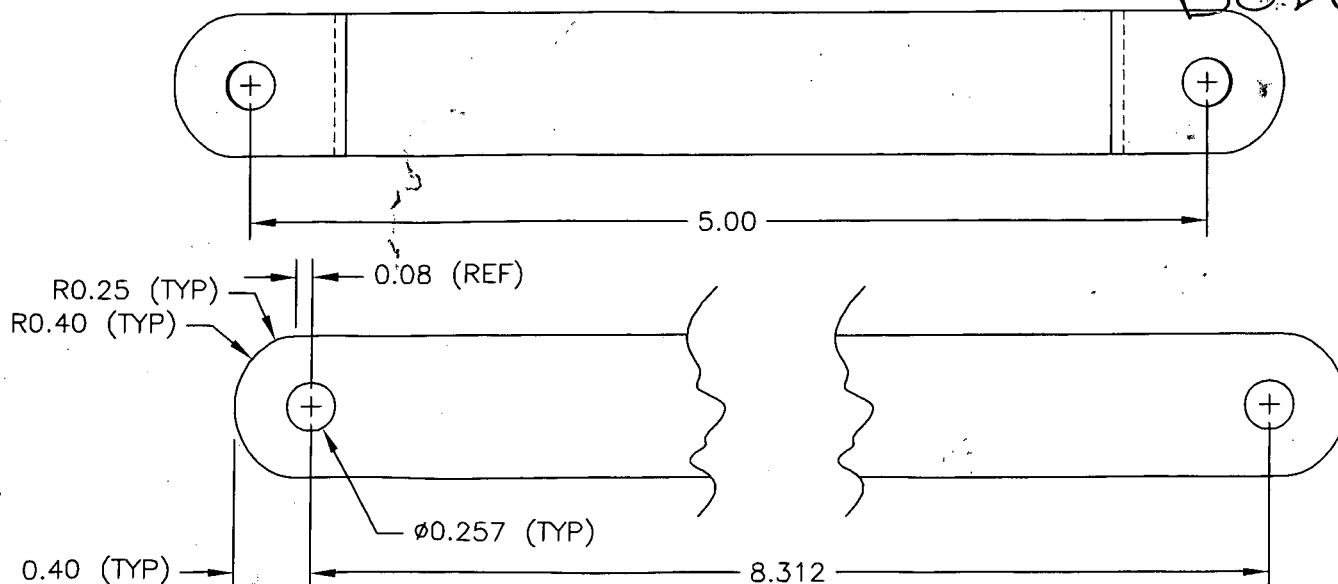
prototype

9+1:2



D2947-3 BEND DETAIL

EST / Prog Done



D2947-3F FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.063 THICK x 0.75 WIDE (REF DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP CORNERS 0.005 TO 0.010

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